



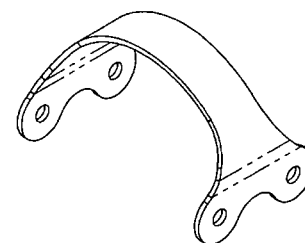
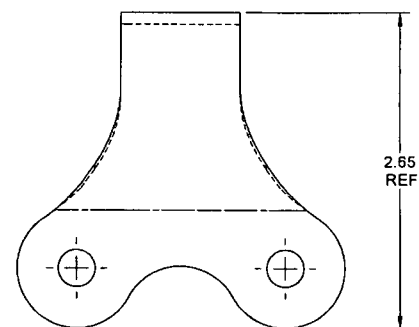
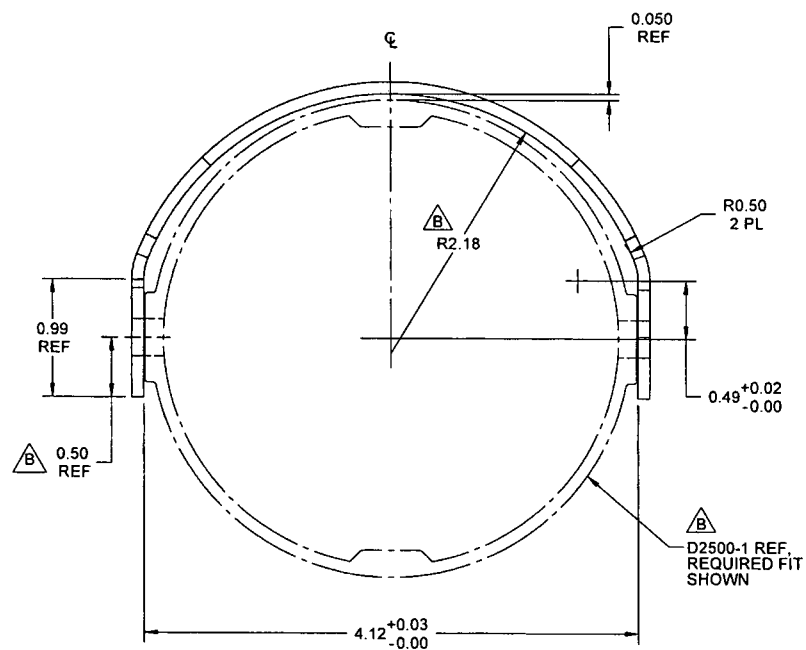
8 7 6 5 4 3 2 1

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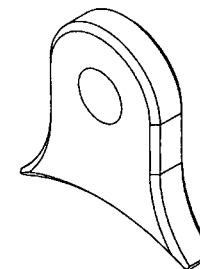
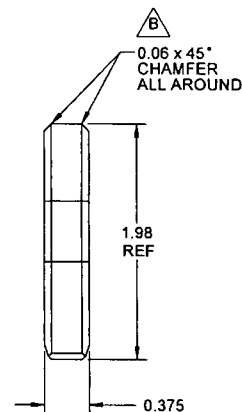
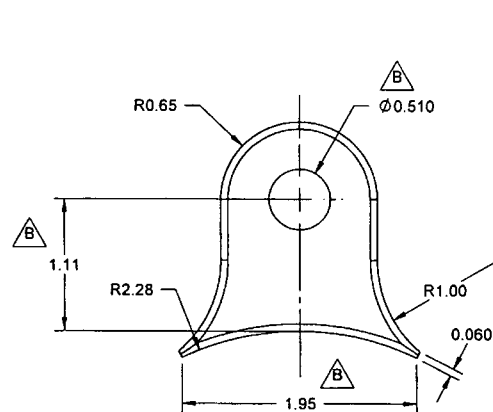
**D3886-3 BRACKET**   
(MAKE FROM D3886-3F)

47819

**RELEASED**  
21671510

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3886	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1



**D3886-1 LUG** (B)

47819

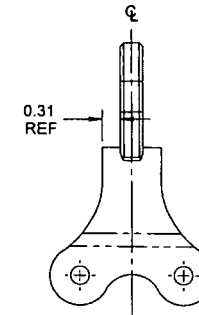
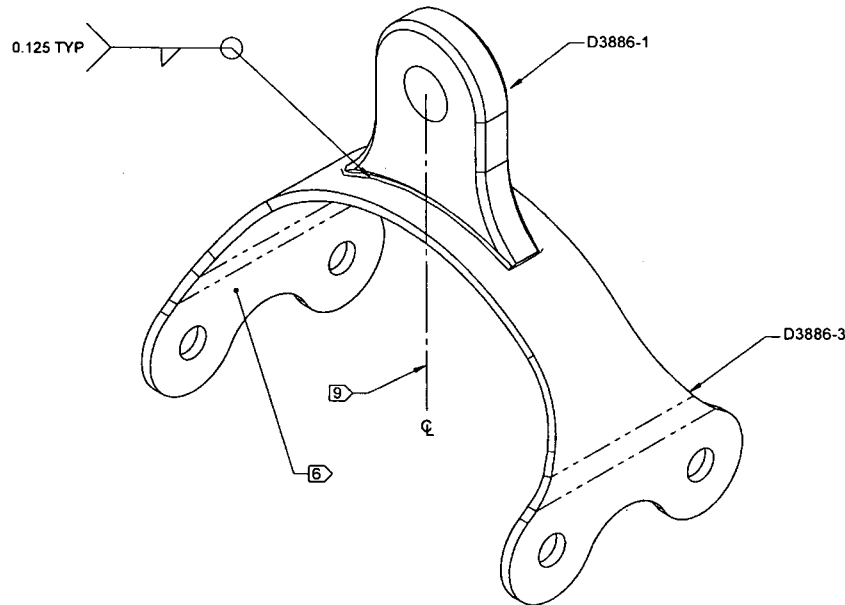
**RELEASED**  
09/06/30

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3886	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
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ITEM	QTY	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



# **D3886-041 LUG ASSEMBLY**

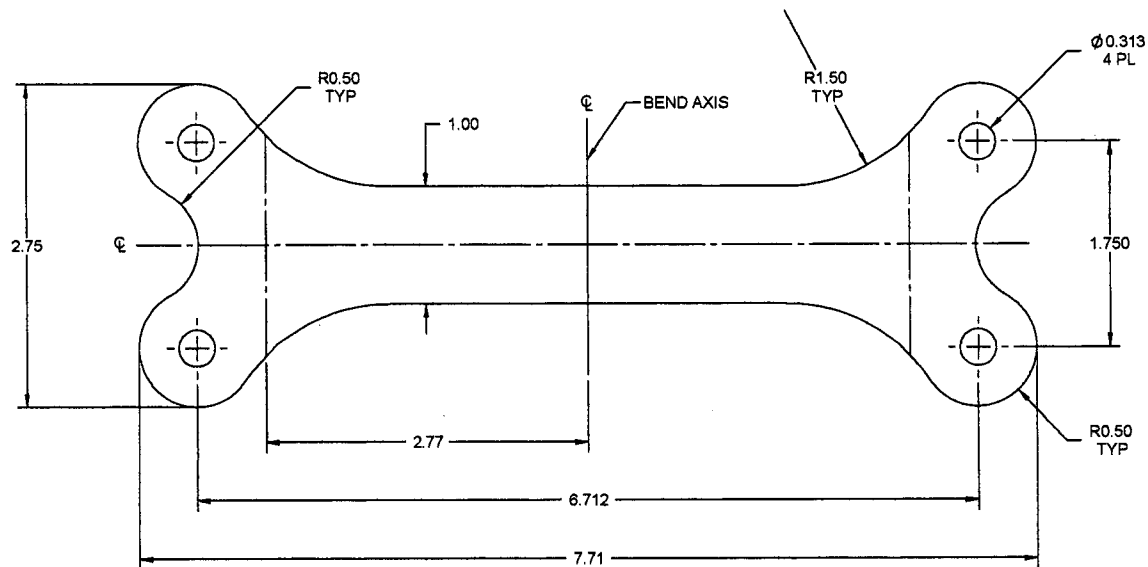
## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE  $\phi$

B	RE-DESIGN D3886-1 (ZN B4-2); RE-DESIGN D3886-3 (ZN A4-3); REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3886</b>	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>LUG ASSEMBLY</b>	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMPARED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

47819

**RELEASED**  
9/6/15



**D3886-3F FLAT PATTERN**

**PRELIMINARY ISSUE**

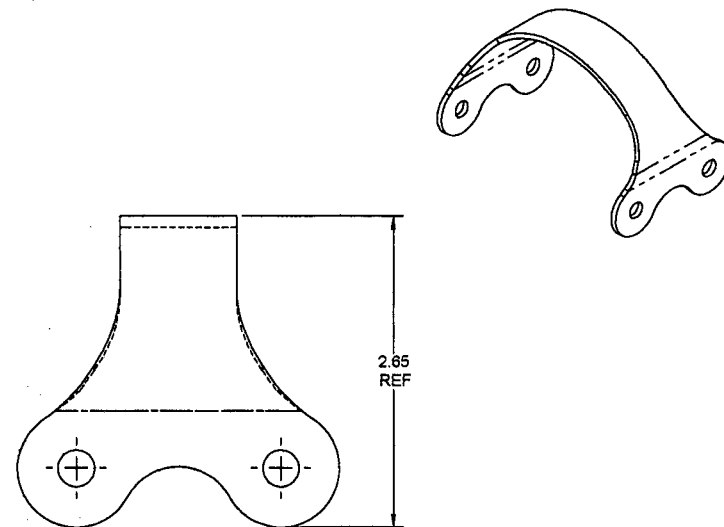
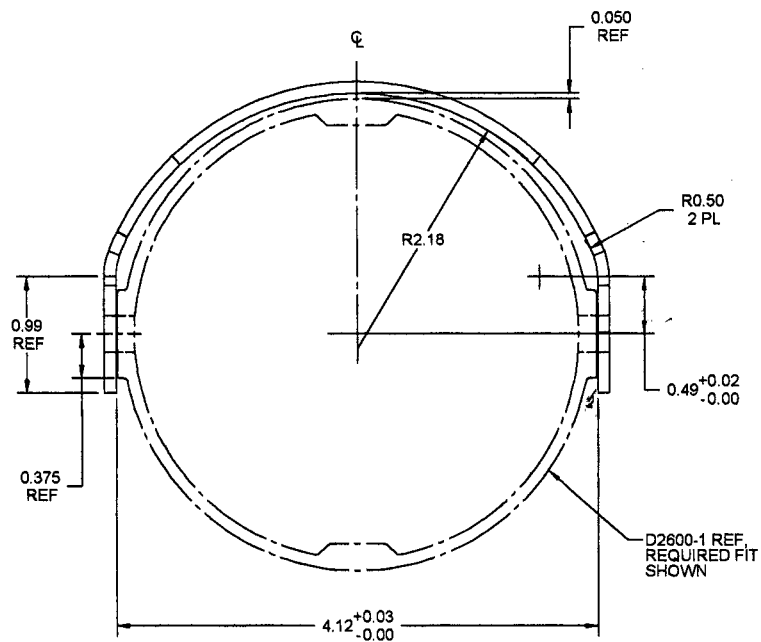
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK, (REF. DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3886	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	LUG ASSEMBLY	NTS
DATE	09.05.11	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

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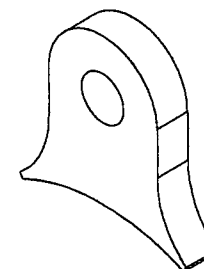
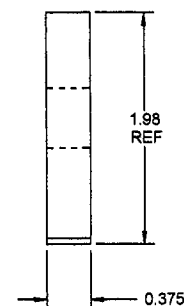
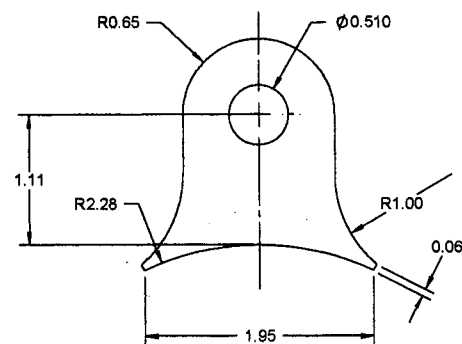


PRELIMINARY ISSUE

**D3886-3 BRACKET**  
(MAKE FROM D3886-3P)

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3886	SHEET 3 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	LUG ASSEMBLY	NTS
DATE	09.05.11	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.                      THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS                      NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT                      WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1



**D3886-1 LUG**

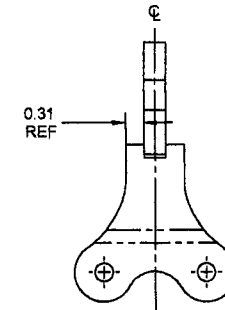
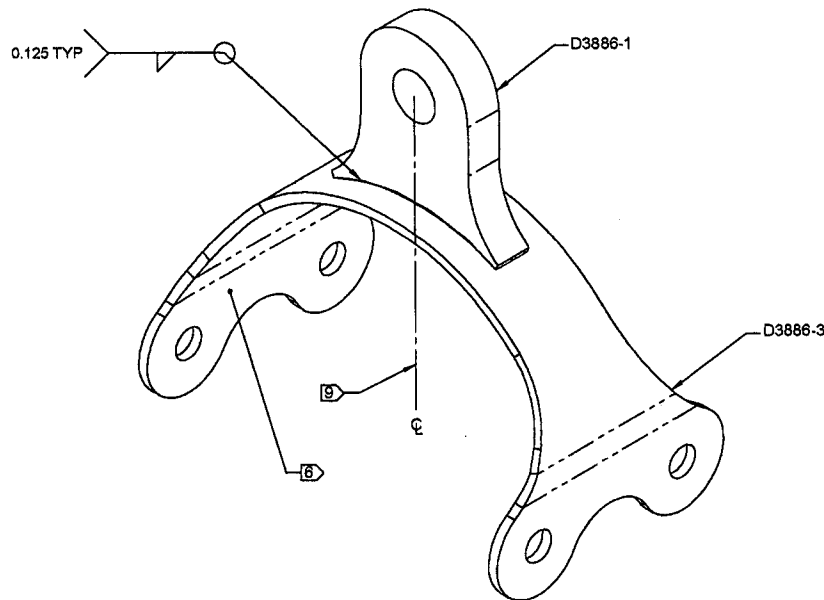
**PRELIMINARY ISSUE**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D3886</b>	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>LUG ASSEMBLY</b>	NTS
DATE	<b>09.05.11</b>	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR CONVEYED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



PRELIMINARY ISSUE

**D3886-041 LUG ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE C

A NEW ISSUE		RF	09.05.11
REV.	DESCRIPTION		BY DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3886	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	LUG ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 08/05/2009 8:48:29 AM  
Usér: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 47819

Part Number: D3886041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE

09-05-08

AUTH

MF 09-06-23

RELEASED

DATE

ENG USE ONLY

09.09.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 08/05/2009 8:48:29 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 47819

Part Number: D3886041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*690527 (4)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

D38861

Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Lug

BATCH: *047779*

*X4*

*EL 9-5-15*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3414 and QSI 004

A/R SS ROD Batch: *M9676*

*EL 9-5-15 (X4)*

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*09-06-15*

10.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

*09-06-16 (4)*

*09-06-16*

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: *2:15pm*

OVEN TEMPERATURE: *400°F*

FINISH TIME: *2:45pm*

*Jil*

*09-06-17*

*(X4)*

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09-06-17*

*(4)*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

\* Identify with Dart P/N and B/N using a permanent fine point marker, then Stock Location: \_\_\_\_\_

*ENG USE ONLY*

*SS*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 08/05/2009 8:48:29 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 47819		
Estimate Number	: 13887		
P.O. Number	:	Part Number	: D3886041
This Issue	: 08/05/2009 S.O. No. :	Drawing Number	: D3886 PREL
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: PREL
Previous Run	: 47480	Material	:
Written By	:	Due Date	: 15/05/2009
Checked & Approved By	: <u>UMF 09-05-08</u>	Qty:	<u>4</u> Um: Each
Comment	: Est Rev:A New Issue 09-04-27 JLM Verified By:EC		

Additional Product

*09.05.09* **PRELIMINARY ISSUE**

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S12GA	304/316 0.100" Sheet
-----	-----------	----------------------



**CERTIFICATE OF CONFORMITY  
REQUIRED**



Comment: Qty.: 0.1523 sf(s)/Unit Total: 0.3045 sf(s)

304/316 stainless steel 0.100" Sheet

Batch: 105130 B 9-5-11

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3886

Dwg Rev: PRE B 9-5-11

Prog Rev: LJM

2-Deburr if necessary B 9-5-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



**ENGINEERING  
APPROVAL**



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr

Form using DT8204 as per Dwg D3886

EB 09/05/12 (4)